



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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Split

D3690-041
Job Sheet 199071-A



Part No: D3690-041

Job Qty: 1 pcs

Part Name: Glareshield Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/19

Job Tracking No:

Due Date: 10/10/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A 08-04-29 new issue DD verified by:ec IPP Rev:B 08-07-14 revB as per dwg DD
verified by:ec IPP Rev:C 08-09-08 added painting DD verified by:EC IPP Rev:D 08-10-07 revC as per dwg DD
verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC 5	1 pcs	10/10/19	10/10/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Spray Paint - 2 - B4B	1 pcs	10/10/19	10/10/19	0.00	3.70	Spray Paint - 1 - B4B		<i>AL 19-9-27</i>
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
140	QC 14	1 pcs	10/10/19	10/10/19	0.00	0.00	QC 14 - 15		
							QC 14 - 2		
							QC 14 - 34		
							QC 14 - 41		
							QC 14 - 51		
							QC 14 - 58		
							QC 14 - 59		
							QC 14 - 9		
							QC 14 - 68		



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S217392



Part: D3690-041

Job No: 199071-A

Serial No/Batch: S214875

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/27/19

				QC 14 - 40	OCT 0 2 2019
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
150	Packaging 3-1 - Stock - B4B	1 pcs	10/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
160	QC 21 - SA	1 pcs	10/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-89

OCT 1 1 2019

F9027

Part Op 120 - (QC5- Inspect part completeness to step on W/Q)
 Descriptions: 130 - (Spray Paint / NDT Room) Primer 138783 Paint 138783
 140 - (QC14- Inspect Spray Paint)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 9/26/19 12:49 PM dart.lacelle.linda



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Tel (613) 632-5200
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D3690-041

Job Sheet 199071



Part No: D3690-041

Job Qty: 2 pcs

Part Name: Glareshield Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Due Date: 9/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 18399

Note: DWG REV C IPP Rev:A 08-04-29 new issue DD verified by:ec IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec IPP Rev:C 08-09-08 added painting DD verified by:EC IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	2 pcs	9/24/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		DAS
							Packaging 1 - 7		58 SEP 18 2019
							Packaging 1 - 8		Q_RQ
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

PRIORITY

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Small Fab - 1 - B4B	DAS
110 Small Fab - 2 - B4B	2 pcs	9/24/19	0.00 6.90		Small Fab - 2 - B4B	58 SEP 19 2019
					Small Fab - 3 - B4B	9-89
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
120 QC 5	2 pcs	9/24/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DA
					QC 5 - 40	SEP 19 2019
					QC 5 - 61	9-89
					QC 5 - 81	
130 Spray Paint - 2 - B4B	2 pcs	9/24/19	0.00 7.41		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
140 QC 14	2 pcs	9/24/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
150 Packaging 3-1 - Stock - B4B	2 pcs	9/24/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	

				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				160 QC 21 - SA	2 pcs	9/24/19	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	
								QC 21 - SA - 53	

Part Op 100 - (Pick Kit)

Descriptions: 110 - (Small Fab)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Spray Paint / NDT Room)

140 - (QC14- Inspect Spray Paint)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Perimeter: 2113983

Paint: 5112463

Job BOM

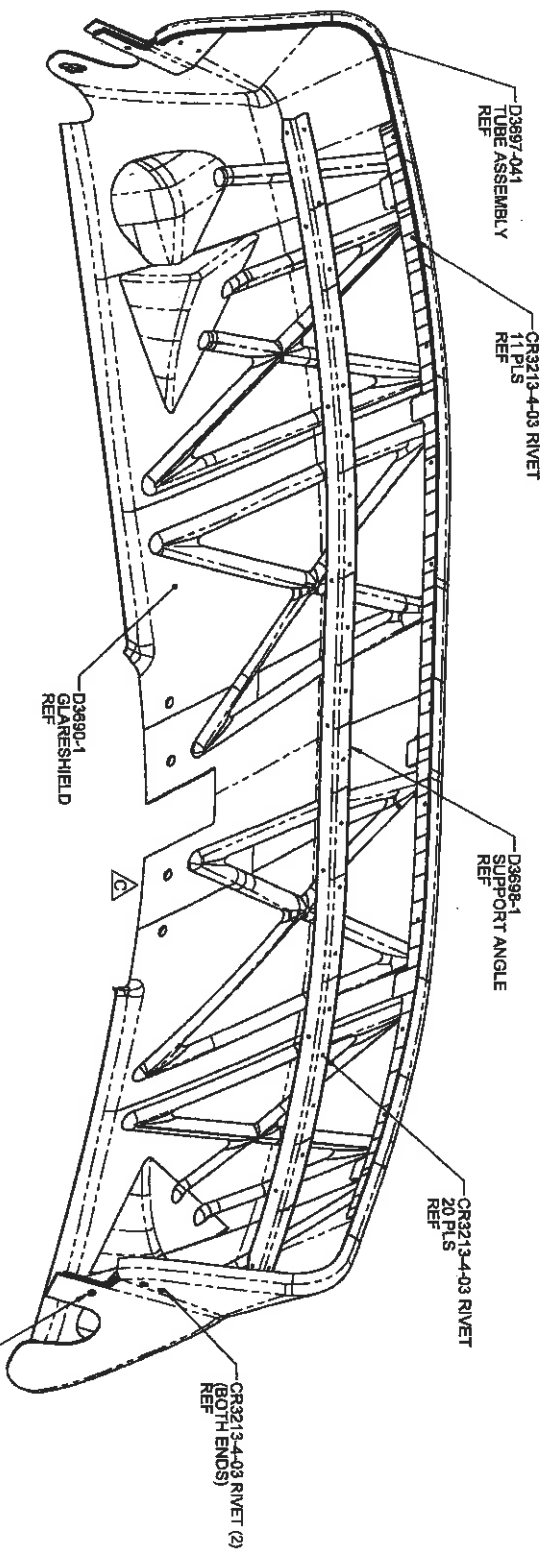
Part / Item	Component Name	Quantity	Operation	Container
CR3213-4-03	Rivet	70 Ea (35 ea)	100-Packaging 1 - Pick Kit	5158593
D3690-1	Glareshield	2 pcs (1 ea)	100-Packaging 1 - Pick Kit	5203089
D3697-041	Tube Assembly	2 pcs (1 ea)	100-Packaging 1 - Pick Kit	5213853
D3698-1	Support Angle	2 pcs (1 ea)	100-Packaging 1 - Pick Kit	5056290
MS20426AD3-5	Rivet	4 Ea (2 ea)	100-Packaging 1 - Pick Kit	4533
NAS1149DN332J	Washer	4 Ea (2 ea)	100-Packaging 1 - Pick Kit	4110783

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	CR3213-4-03	70	197	0
	D3690-1	2	3	0
	D3697-041	2	2	0
	D3698-1	2	4	0
	MS20426AD3-5	4	435	0
	NAS1149DN332J	4	628	0

Part Specifications
Specifications could not be found.

Plex 9/18/19 9:59 AM dart.lacelle.linda



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960U3	WASHER (OR NAS1149DN32J)
35	CR3213-4-03	RIVET

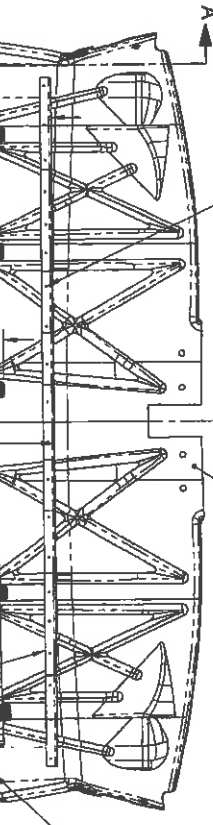
D3690-041 GLARESHIELD ASSEMBLY

SHEET 1 PL MS20428AD3-5 RIVET WAS MS20428AD3-4 CR3213-4-03 RIVET WAS MS20428AD3-4 WASHER QTY WAS 8 VIEWS UPDATED ACCORDINGLY. WASHER QTY CHANGED TO 10. SHADING REMOVED. FROM ALL VIEWS FOR CLARITY.		AJS 08.09.02
B ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A & B & C & D. ADD MIN THICKNESS. SHEET 3 ZONE A & B		RF 08.08.24
A NEW ISSUE		RF 08.05.28
DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE 08.09.02	RF RF RF RF RF RF	DESCRIPTION DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA DRAWING NO. D3690 SHEET 1 OF 3 TITLE GLARESHIELD ASSEMBLY SCALE NTS

RELEASED

TRANSFER DRILL Ø0.128
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

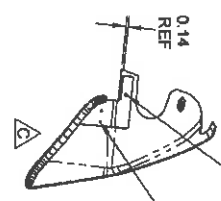
D3690-1
GLARESHIELD
REF



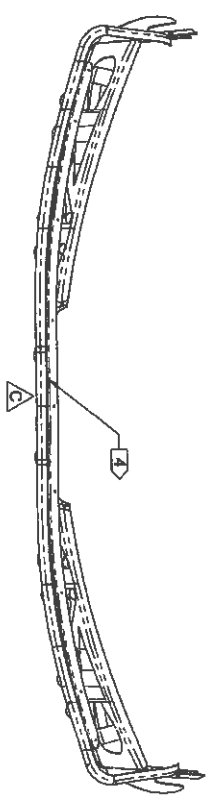
EQUAL DIMENSION
AT BOTH ENDS

TRANSFER DRILL Ø0.128
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 11 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

TRANSFER DRILL Ø0.144
AT THIS LOCATION
FROM D3697-041 TO D3690-1
(NO HARDWARE INSTALLED)



SECTION A-A



D3690-041 GLARESHIELD ASSEMBLY

- NOTES:
- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
 - 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39 50 PER DART OSI 006 4.2
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFICATION: ETCH WITH DART PIN D3690-041 & B/N ON INSIDE OF PART
 - 5) WEIGHT: 2.98 lbs
 - 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	
MFG. APPR.	RF	D3690
APPROVED	RF	
DE APPR.	RF	
DATE	08.09.02	GLARESHIELD ASSEMBLY
		SCALE
		NTS

REVISIONS

DATE

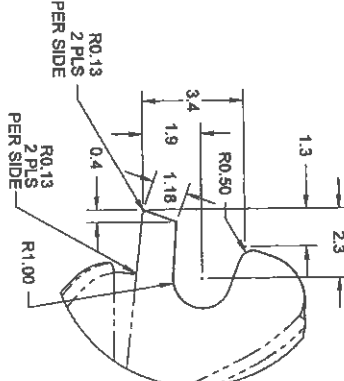
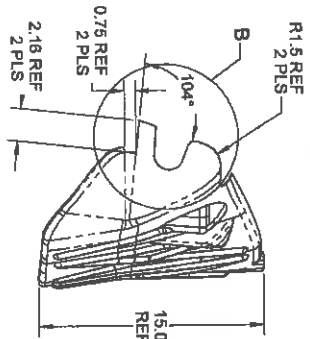
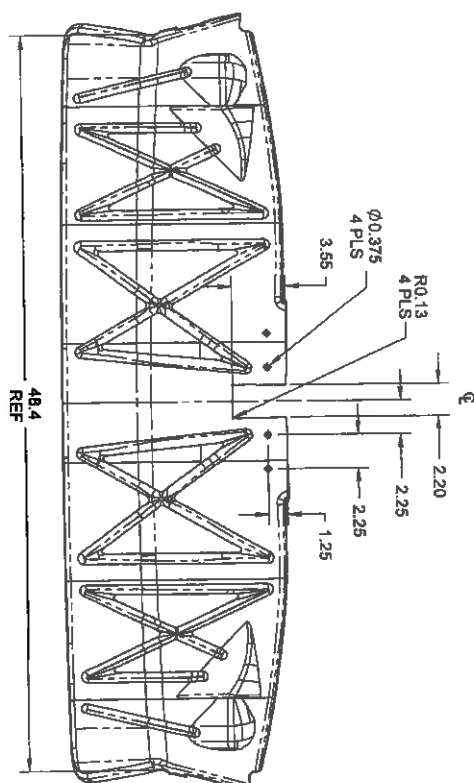
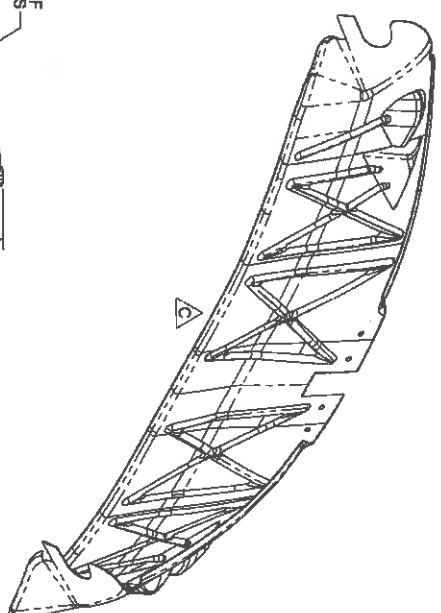
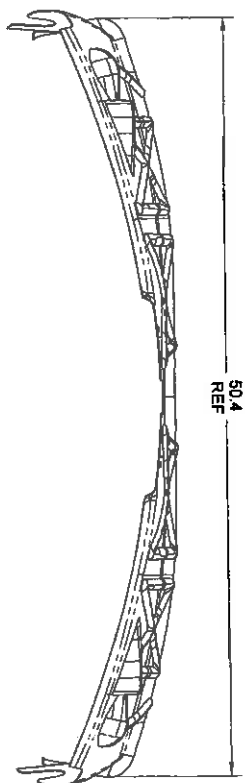
DESCRIPTION

BY

APP'D

1

RELEASED



D3690-1 GLARESHIELD

- NOTES:**
- 1) MATERIAL: F8006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
 - 2) TOOLING: REF DART SPEC M L EXS 093-F8006-02
 - 3) FINISH: NONE
 - 4) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: 2.5 lbs
 - 9) MINIMUM THICKNESS AFTER FORMING IS 0.040

RELEASED

DETAIL B
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	REV. C
MFG. APPR.		D3690
APPROVED		GLARESHIELD ASSEMBLY
DATE	08.09.02	SCALE NTS

THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE MANUFACTURE OF THE GLARESHIELD ONLY. NO OTHER REPRODUCTION IS ALLOWED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.